

BAND SAWING TIPS

FOR OPTIMUM BLADE LIFE AND MOST EFFICIENT OPERATION:

1. **BREAK IN NEW BLADES** - When starting a new blade, use recommended blade speed, but reduce the normal feed pressure by 50%. Over the first 50 to 100 square inches of cutting, gradually increase the feed pressure until normal feed rates are reached.
2. **USE RECOMMENDED BLADE SPEED**
3. **USE PROPER BLADE TENSION** - Recommended blade tensions are:
 - Bimetal blades - 30,000 to 35,000 psi
 - Carbon Hard Edge Flex Back blades - 15,000 to 20,000 psi
 - Carbon Hard Back blades - 20,000 to 25,000 psiRelease the blade tension when the machine is not in use.
4. **USE PROPER TOOTH SIZE** - There should be a minimum of 3 teeth for bimetal blades and 6 teeth for carbon blades engaged in the work at all times. For mild steel and other easy to machine material, the optimum number of teeth engaged in the work is 6 to 12. For hard material, 12 to 24.
5. **USE COOLANT** - Whenever possible, use the proper concentration of a good cutting fluid or coolant. Coolant manufacturers' recommended concentrations for various materials should be observed. Cast iron and D2 Die Tool Steel should be cut dry.
6. **CLAMP THE WORK PIECE TIGHTLY** - Make sure the work piece is securely vised or clamped to prevent movement or excess vibration during cutting.
7. **POSITION THE BLADE GUIDE ARMS AS CLOSE AS POSSIBLE TO THE WORK PIECE**
8. **CHECK BLADE GUIDES** - Make sure the blade guide gap is correct for the thickness of the blade being used to prevent excess movement during use. Make sure the guides do not hit the sides of the teeth in the area between the tooth gullets and tooth tips. Replace worn or damaged blade guides.

CAUTION: FAILURE TO OBSERVE THESE PROCEDURES MAY RESULT IN BLADE DAMAGE, MACHINE DAMAGE, WORK PIECE DAMAGE OR BODILY INJURY.

TO REDUCE THE RISK OF INJURY WHEN HANDLING BAND SAW BLADES, PROTECTIVE SAFETY GLASSES AND GLOVES SHOULD BE WORN.